• Wednesday, 3/26/2008 9:52:44 AM Date: User Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR DOUBLER Customer Job Number : 38163 **Estimate Number** : 12680 : D3594041 P.O. Number Part Number : 3/26/2008 S.O. No. : **Drawing Number** · D3594 REV A This Issue : N/A : NC Project Number Prsht Rev. : A : SMALL /MED FAB : // **Drawing Revision** First Issue Type : 33874 Material Previous Run 10 Um: Each : 4/4/2008 Qty: **Due Date** Written By Checked & Approved By Comment : Est Rev : A New Issue 07-01-22 **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 6061-T6 .080 Sheet 1.0 M6061T6S080 Comment: Qty.: 0.5775 sf(s) Total: 0.0578 sf(s)/Unit 6061-T6 .080 Sheet Batch: WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev:\_\_ Prog Rev:\_\_ 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 C'SINK AS [PER dwg d3594

## Dart Aerospace Ltd

W/O:				WORK OF	RDER CHA	NGES					
DATE	STEP	,	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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Part No	:		PAR #:	Fault Category:		NO	R: Yes	No DQ	A:	_ Date: _	
	1						QA·	N/C Close	q.	Date	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Varification						
DATE	STEP	Section A	Initial Chief Eng			Verification Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

User:	Kım	Johnst <b>on</b>	Process Sheet
. '- Ci	ustomer:	CU-DAR001 Dart Helicopters Services	Drawing Name: DOOR DOUBLER
Z	N 1	20462	Down Numbers D2504041
Job Nun	Number:		Part Number: D3594041
<b>702</b> (141)			
Seq. #:	:	Machine Or Operation:	Description :
(	6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comme	nt: INSPECT WORK TO CURRENT S	STEP & SOLOHOY (XCT)
	7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comme	nt: HAND FINISHING RESOURCE #1	
	0.0	Chemical Conversion Coat as per	QSI 005 4.1 YX 08.04-04 XZ6 INSPECT POWDER COAT/CHEMICAL CONVERSION
8	8.0		INSPECT POWDER COAT/CHEMICAL CONVERSION
		nt: INSPECT POWDER COAT/CHEM	
ξ	9:0	MS210695	Anchor nuts
	Comme	•	tal: 10.0000 Each(s)
		Anchor nuts Batch:	9 (19x) M107938 (7x) Boxlos
10	0.0	MS20426AD44	River
	Commer		tal: 20.0000 Each(s)
		Rivet Batch: M/O21	B08/05/00
11	1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	- Address v av		
	Commer	it: SMALL & MEDIUM FAB RESOUR Install Nut Plate as per Dwg D3594	
12	2.0	QC5	INSPECT WORK TO OURRENT STEP
			couls
		t: INSPECT WORK TO CURRENT S	
13	3.0	PACKAGING 1	PACKAGING RESOURCE #1
	· Commer	t: PACKAGING RESOURCE #1	
		Identify and Stock	/// dd = (a)
		Location:57240	- (26)

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Page 2

### **Dart Aerospace Ltd**

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W/O:			WC	RK ORDER CHAN	IGES					1-1-A
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
\u00e4										
Part No	):	PAR #:	Fault Cateç		NCI	R: Yes	No <b>DQ</b> A	\:	Date:	
				•		QA: N	/C Closed	l:	_ Date: _	
NCR:		1	WORK ORDE	ER NON-CONFORM	MANCE	(NCR	R)			. / d - d t t
DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Section	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Wednesday, 3/26/2008 9:52:44 AM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Part Number: D3594041

Job Number: 38163

Seq. #:

Job Number:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace	Ltd								
W/O:		All and a second	W	ORK ORDER CH	ANGES	*				
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approvai QC Inspector
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										3 ,
							<u> </u>			
Part No	:	PAR #:	Fault Cat	egory:	NCI	R: Yes	No <b>DQ</b>	A:	_ Date:	
						QA: N	C Close	d:	_ Date: _	
NCR:			WORK ORD	DER NON-CONFO	RMANCE	(NCR	)			
DATE	OTED	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign & Date	Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

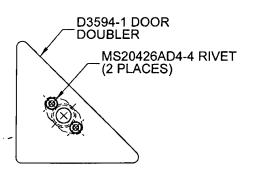
DART AEROSPACE LTD	Work Order: 38167	3
Description: Door Doubler	Part Number: D359	4-1
Inspection Dwg: D3594 Rev: A	Page 1	of 1

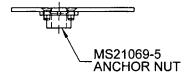
	FIRS	ST ARTICLE	INSPECT	ION CH	ECKLIST				
	X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
2.57	+/-0.030	6.57.6	×						
1.000	+/-0.010	1.001	×						
0.530	+/-0.010	,5,39	¥						
1.000	+/-0.010	1001	*						
0.718	+/-0.010	7,19	*						
0.359	+/-0.010	,359	*						
Ø0.129	+0.005/-0.001	139	X						
Ø0.323	+0.006/-0.001	337	×						
Measured by:	R 8-3-28	Audited by:	<del></del>	1/2	Prototype Approx	val: N/A ate: N/A			
Rev         Date           A         07.07.18	Change New Issue	P/O D359	4-041		Revise KJ/JLN	Approved			



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	DESIG	1	DRAW	BY	DART AER	OSPACE LTD
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	CHECK	ED,/	APPRO	VED /	DRAWING NO.	REV. A
		#		TH	D3594	SHEET 1 OF 3
	DATE				TITLE	SCALE
	l	07.0	)4.13		DOUBLER	1:1
_	REV		DATE		DESC	CRIPTION
	Α		07	7.04.13	NEW ISSUE	

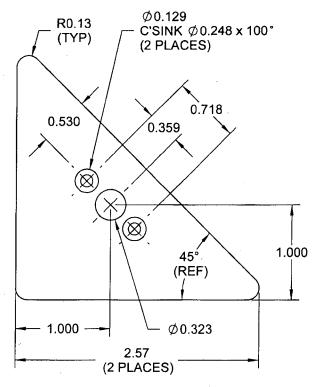






# D3594-041 DOOR DOUBLER ASSEMBLY ASSEMBLY SCALE 1:2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET



D3594-1 DOOR DOUBLER /1\ /2\

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NO.-

WORK ORDER

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027

(REF. DART SPEC. M6061T6S.080)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

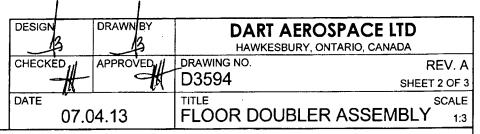
4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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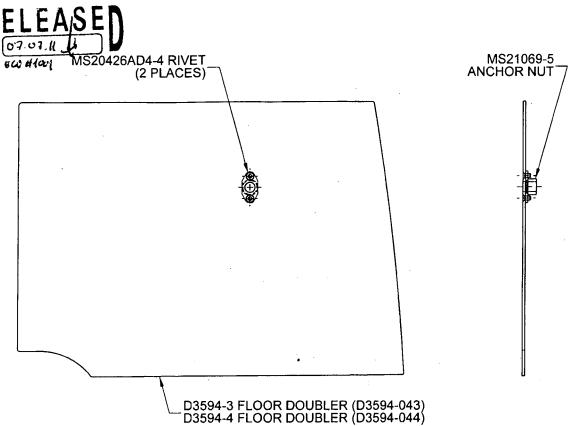




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WORKORDER



### D3594-043 FLOOR DOUBLER ASSEMBLY (D3594-044 OPPOSITE)

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	Х	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)

2) FINISH: CHÈMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER

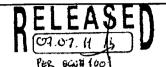
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

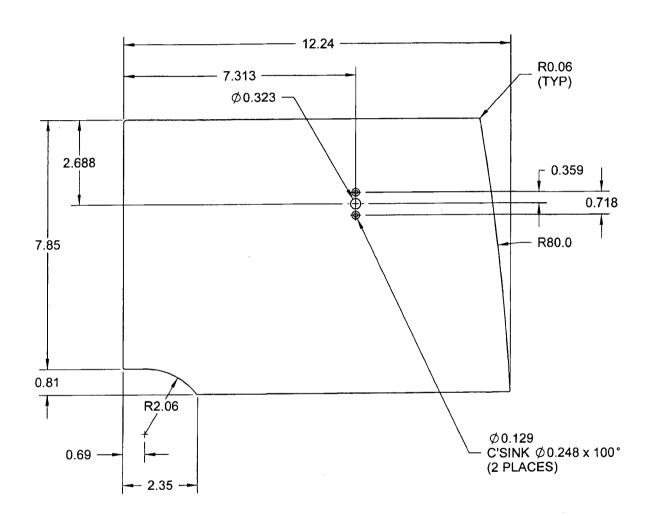
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD DESIGN DRAWN BY HAWKESBURY, ONTARIO, CANADA APPROVED DRAWING NO. CHECKED REV. A D3594 SHEET 3 OF 3 TITLE DATE SCALE **DOUBLER** 07.04.13 1:3





D3594-3 FLOOR DOUBLER (D3594-4 OPPOSITE)

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